



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4293-1

Job Sheet 183243



Part No: D4293-1

Job Qty: 4 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-15 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/28/18	9/28/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	4 pcs	9/28/18	9/28/18	0.00	0.40	Bandsaw1		
110	CNC Vertical Machining	4 pcs	9/28/18	9/28/18	0.00	3.64	HAAS 5 Axis		
120	QC	4 pcs	9/28/18	9/28/18	0.00	0.00	QC2 Machining-2		
130	QC	4 pcs	9/28/18	9/28/18	0.00	0.00	QC8 Machining-2		
140	HandFinish	4 pcs	9/28/18	9/28/18	0.00	0.43	HandFinish1		
150	Powdercoat	4 pcs	9/28/18	9/28/18	0.00	0.36	Powdercoat1		
160	QC	4 pcs	9/28/18	9/28/18	0.00	0.00	QC3		
170	Small Fab	4 pcs	9/28/18	9/28/18	0.00	0.25	Small Fab-6		
180	QC	4 pcs	9/28/18	9/28/18	0.00	0.00	QC5		
190	Packaging	4 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-2		
200	QC21-SA	4 Ea	9/28/18	9/28/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank to 6.800" Batch: *****GRAIN ALONG 4"*****

Descriptions: 110 - 1-Machine per folio FB005 DWG REV: FOLIO REV: 2- Deburr and break all sharp edges

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum MASK THREADED HOLE

160 - QC3- Inspect Part Finish

170 - INSTAL HELICOIL AS PER DWG

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

M 138451 START: 10:25 OUT: 300 FINISH: 10:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4" Wide	2.2800 ft (.57 ea)	90-Start up Operation	5119 972
MS21209F1-10	Heli Coil	4 Ea (1 ea)	170-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	2	27	0
170-Small Fab	MS21209F1-10	4	20	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Part Specifications

Specifications could not be found.

Plex 9/14/18 10:20 AM Dart.lajeunesse.marie



Container No: S119973



Part: D4293 - 1

Job No: 183243

Serial No/Batch: S119973

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/20/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

DART AEROSPACE LTD		Work Order:	183243
Description: Fitting		Part Number:	D4293-1
Inspection Dwg: D4293 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.305	+0.030/-0.010	.305	✓		SLIC	vern
R0.063	+/-0.010	.063	✓		Rad	gauge
0.125	+0.030/-0.010	.124	✓		SLIC	vern
0.88	+/-0.030	.874	✓			
0.500	+/-0.010	.501	✓			
0.82	+/-0.030	.825	✓			
0.39	+/-0.030	.394	✓			
0.088	+/-0.010	.086	✓			
0.625	+/-0.010	.632	✓			
1.730	+/-0.010	1.730	✓			
0.800	+/-0.010	.800	✓			
0.275	+/-0.010	.277	✓			
1.13	+/-0.030	1.114	✓			
3.11	+/-0.030	3.110	✓			
3.44	+/-0.030	3.440	✓			
2.450	+/-0.010	2.451	✓			
1.325	+/-0.010	1.315	✓			
0.305	+/-0.010	.305	✓			
2.84	+/-0.030	2.834	✓			
5.86	+/-0.030	5.858	✓			
6.52	+/-0.030	6.525	✓			
0.19	+/-0.030	.190	✓			
Ø0.272	+0.006/-0.001	.272	✓			
Ø0.323	+0.006/-0.001	.323	✓			
1.75	+/-0.030	1.753	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
4.875	+/-0.010	4.878	✓			
0.493	+/-0.010	.490	✓			
Ø0.201	+0.005/-0.001	.201	✓			
0.800 deep	+/-0.010	.800	✓			
CSK Ø0.320 x 100°	+/-0.010	.328	✓			
0.663	+/-0.010	.658	✓			
C-bore Ø0.765	+/-0.010	.765	✓			
6.20	+/-0.030	6.200	✓			
R0.13	+/-0.030	.130	✓		Rad gauge	
1.125	+/-0.010	1.126	✓			
Ø0.381	+0.000/-0.001	.381	✓		✓	

DART AEROSPACE LTD		Work Order: 183243
Description: Fitting		Part Number: D4293-1
Inspection Dwg: D4293	Rev: C	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.388	+/-0.010	1.389	✓		SLIO	Vein
R0.031	+/-0.010	.031	✓		Rad	gauge
4.500	+/-0.010	4.500	✓		SLIO	Vein
R1.370	+/-0.010	1.370	✓			
2.250	+/-0.010	2.250	✓			
0.680	+/-0.010	.679	✓			
1.65	+/-0.030	1.647	✓			
1.42	+/-0.030	1.417	✓			

Measured by: DAS 20 9-99	Audited by: D.F.	Preliminary Approval:
Date: 18-10-19	Date: 18-10-20	Date:

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	